

Work Order ID 52868



Page 1

October 16, 2009 10:06:46 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID: M

Stop



Item Name: Replacement Skidtube

Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PS*

Date: *09-10-16*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

Rev M

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

*N/A*

# Work Order ID 52868



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Item ID: D206-642-541  
Revision ID: M  
Item Name: Replacement Skidtube

Accept



Setup Start



Stop



Start Date: 16/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

0.00

Memo

1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274.

9-10-19

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

SPD 09-10-21

3- weld fwd cap as per dwg D3274 and OSI004

AR Aluminum Rod Batch:

M10923 / M111999 BB 09-10-21

4- grind fwd cap weld on top surface only

BE 09-10-21

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

9-10-22

8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

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Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

SAD 09-10-22



Hand Finishing

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

27 S. S. S.



Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

27 S. S. S.



Quality Control

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Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R ☐ Sikaflex-291 ☐ 11/23/09 ☐

Sikaflex expire date: ☐ 11/23/09 ☐

Start: ☐ 9/16/09 ☐ Time: ☐ 8:00 ☐

Finish: ☐ 9/16/09 ☐ Time: ☐ 10:20 AM

(Adhere for 12 hours)

AW 9-10-26

1 11/10/29

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

2) 8/16/10

11/10/29

Quality Control

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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

170

0.00



Skidtubes

1 11 9/11/2

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-IT2  
OPEN HOLES TO .297" . Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT895 FWD  
END OF TUBE  
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)  
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

27 Skidtube

h2 3004

L<sup>o</sup> 4.4°

ed

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Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

190

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod  
A/R ☐ Aluminum Rod ☒ M112507 86 09/11/03

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

86 09/11/03

86 09/11/03

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Stop



Start Date: 16/10/2009 Start Qty: 1.00  
Required Date: 02/11/2009 Req'd Qty: 1.00



Cust Item ID:  
Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

QC10- Inspect visual per QSI004- ground welds

0.00



⇒ 8 or 10/3

QC

Memo

0.00

Quality Control

220

Pressure Wash per QSI005 4.3

0.00



⇒ 11 or 10/00

HandFinish

Memo

0.00

Hand Finishing

230

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



M112148

⇒ 11 or 11/04

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:00pm  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 1:30pm





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Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	HAND FINISHING RESOURCE #1	0.00				X1			
	HandFinish								
Hand Finishing	Memo 1-Install wearpads & gaskets as per Dwg D3274. 2-Install ring as per Dwg D3274 A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> M112391 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 10/20 3-Inspect for foreign objects as per QSI 024 4-Spray inside of tube on both sides of web with LPS-3 A/R LPS-3 Batch: <u>11/14</u> 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> M112391 <input type="checkbox"/> Sikaflex expire date: <input type="checkbox"/> 10/20	0.00							
280	QC5- Inspect part completeness to step on W/O	0.00							
	QC								
Quality Control	Memo 27 8 01/11/14	0.00							

# Picklist Print

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Page 1

Work Order ID: 52868

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-1-190RevD1		Manufactured	No			110	Each	65.0000	1.0000			



Extrusion Round 3" 206

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

65

47575

65

110

Each

27.0000

1.0000

D3285-1RevA

Manufactured

No



Cap

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

27

47635

27

150

Each

5.0000

1.0000

D3282-041RevC

Manufactured

No



Float Web (206L/407)

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

LG

5

48389

5

B 52 696

1

11/10/20

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Work Order ID: 52868

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube


Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			190	Each	593.0000	12.0000			
												
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG 83

51529 83

Main Warehouse

ST 510

36013 5

47112 383

48271 122

D3275-1RevA1

Manufactured No



Crossbolt Spacer

190 Each 28.0000 12.0000



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 28

47464 1

48117 15

48270 12

B52510 12 BE 09/11/02

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Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

CR3212-4-03

Purchased

No

250

Each

310.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

111359

112314

15984

310

96

200

14

250

Each

93.0000

1.0000

D3415-041RevB

Manufactured

No



Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

33842

93

93

250

Each

267.0000

2.0000

CCR264SS3-3

Purchased

No



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

111548

111827

112314

267

52

115

100

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Parent Item Name: Replacement Skidtube

Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	5,373.000	78.0000			



Insert

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

5373

110511

5373

270

Each

41.0000

1.0000

X 78 MD 09/11/12

D3536-15RevA

Manufactured

No



Gasket

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

41

47711

3

48159

12

51600

26

X 1 MD 09/11/13

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Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bit Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			270	Each	30.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP	12	
(51609)	12	
Main Warehouse		
ST	18	
30754	1	
47713	17	

XI MD 09/11/13

D3536-35RevA

Manufactured No

270

Each

39.0000

1.0000



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	39	
48160	13	
(51628)	26	

XI MD 09/11/13

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Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-39RevA		Manufactured	No			270	Each	28.0000	1.0000			
Gasket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 12

51637 12

Main Warehouse

ST 16

44648 1

47714 4

48161 11

D3535-15RevB

Manufactured No

270

Each

31.0000

1.0000

Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP 18

51671 18

Main Warehouse

ST 13

30750 4

42233 1

48155 8

XT mvd 09/11/13

XT mvd 09/11/13

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-35RevB		Manufactured	No			270	Each	36.0000	1.0000			
Wearshoe												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

36

48157

10

51608

26

270

Each

26.0000

1.0000

XI mo 09/11/13

D3535-39RevB

Manufactured

No



Wearshoe

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

FP

13

51619

13

Main Warehouse

ST

13

48158

13

XI mo 09/11/13

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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-23RevB		Manufactured	No			270	Each	24.0000	1.0000			
Wearshoe												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

13

51618

13

Main Warehouse

ST

11

48156

11

D3537-3RevC

Manufactured No

270

Each

69.0000

1.0000



Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

69

30758

7

33881

17

35697

45

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Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC		Manufactured	No			270	Each	284.0000	9.0000			

Wearpad

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

265

51624

103

51678

162

Main Warehouse

ST

17

51918

17

AN960C10L

Purchased

No

270

Each

4,396.000 80.0000

washer

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

4296

112116

993

112612

3303

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Required Date: 02/11/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C416  washer		Purchased	No			270	Each	704.0000	1.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

704

100993

704

D3672-1 RevB

Manufactured

No



Phenolic Washer

270

Each

2,056.0000 2.0000



X1 MD 09/11/13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1556

39275

19

42329

15

47628

522

52505

1000

Main Warehouse

ST117

500

51674

500

X2 MD 09/11/13

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Start Date: 16/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	On Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A		Purchased	No			270	Each	1,826.000	80.0000			

BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1826	
112314	40	
112720	124	
112724	178	
112794	984	
112829	500	

X 80 MD 09/11/13

AN4C5A

Purchased

No

270

Each

601.0000

1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	601	
104936	19	
110552	80	
112243	500	
18918	2	

X 1 MD 09/11/13

# Picklist Print

Page 12

October 16, 2009 10:06:52 AM

Work Order ID: 52868

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 16/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin. Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC		Manufactured	No			270	Each	53.0000	1.0000			



Aft Cap

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	53	
20208	0	
43801	1	
46327	4	
48109	48	

D3413-1RevA

Manufactured No

270

Each

40.0000

1.0000



Ring

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	20	
48123	20	
Main Warehouse		
ST473	20	
51586	20	

X1 MD 09/11/13

X1 MD 09/11/13

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 62561

**DART**

PL 09-10-21

RELEASED

07.02.12

DEO ATTACHED

DESIGN	CP	DRAWN BY	PH	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
				D3274	SHEET 1 OF 4
DATE				TITLE	SCALE
06.12.19				SKIDTUBE ASSEMBLY	NTS
A	04.03.15		NEW ISSUE		
B	04.08.09		MOVE SADDLE HOLE: 42.14 WAS 42.76		
C	05.03.16		ADD -043; NEW INSERTS		
D	06.12.19		NEW INSERTS, SS WEARSHOE + GASKET		

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

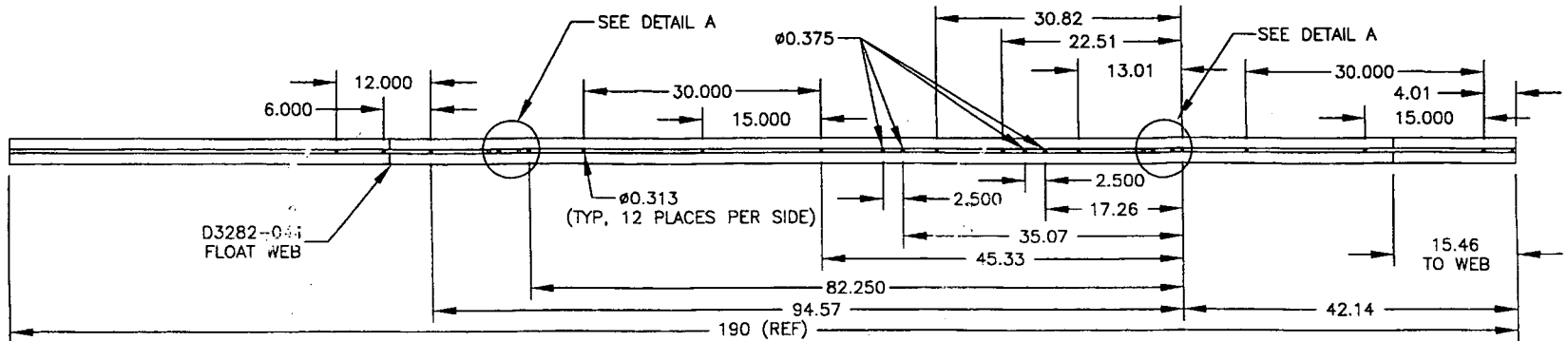
**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1  
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

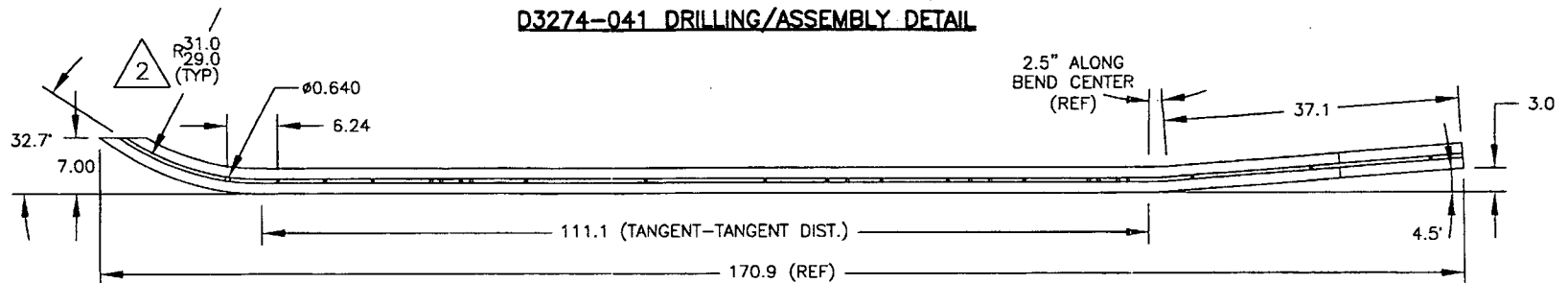
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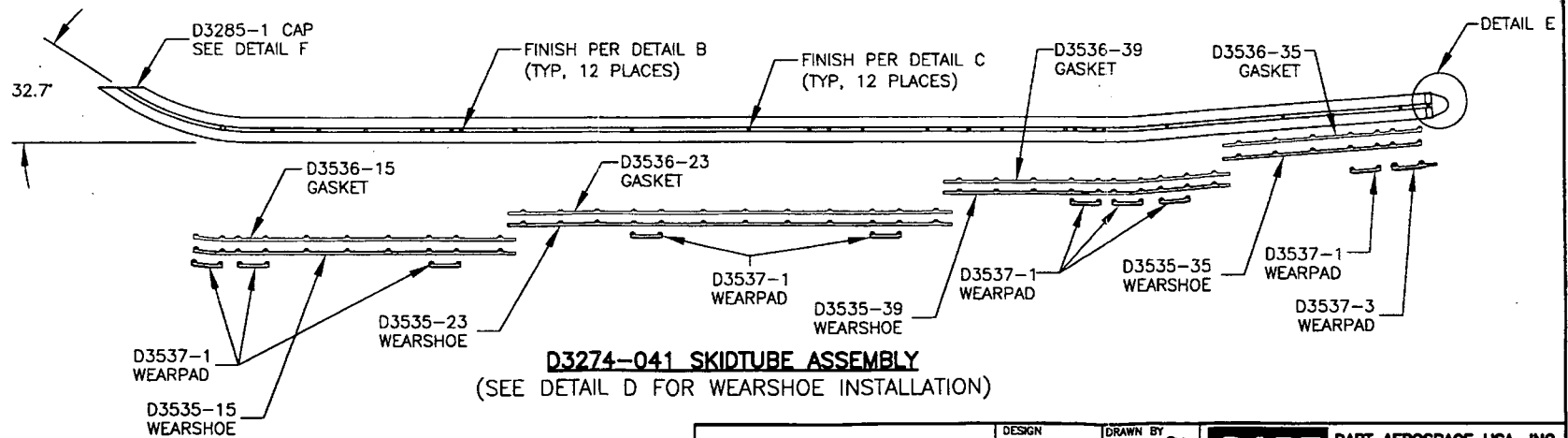
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**D3274-041 DRILLING/ASSEMBLY DETAIL**



**D3274-041 BEND/DRILLING DETAIL**



**D3274-041 SKIDTUBE ASSEMBLY**

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

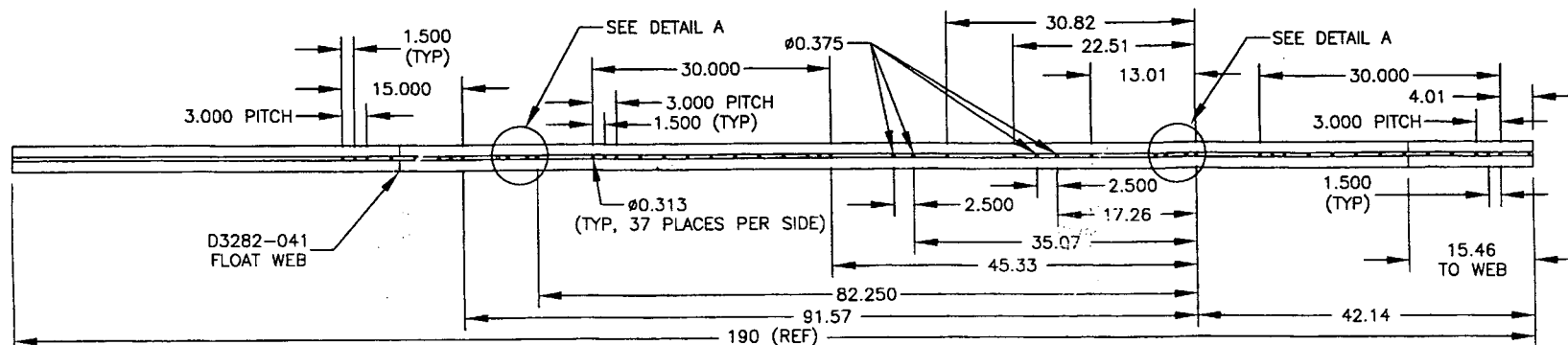
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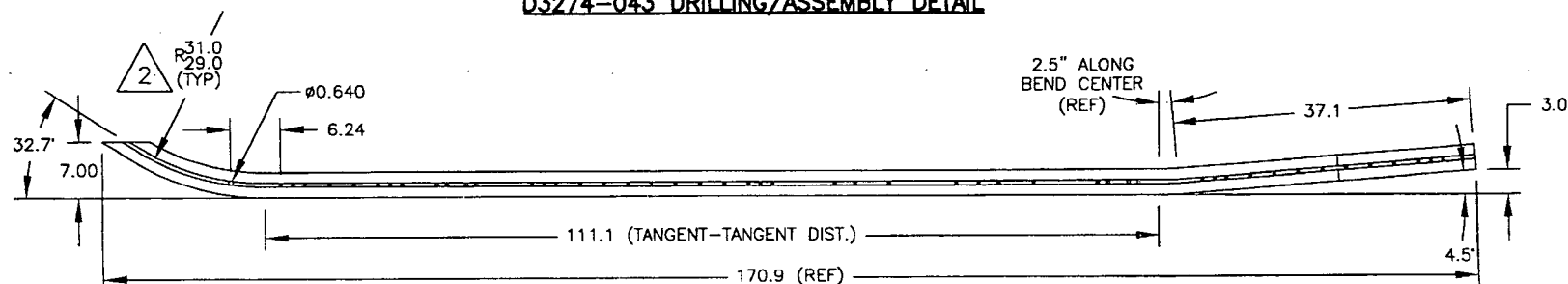
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		DATE	06.12.19			TITLE SKIDTUBE ASSEMBLY	SCALE 1:15

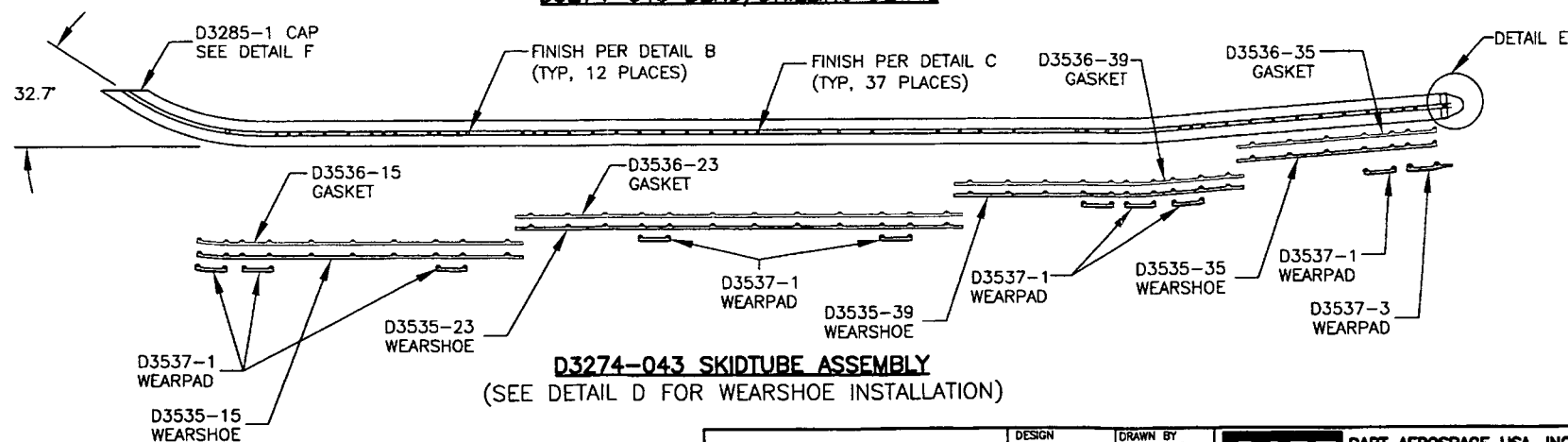
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**D3274-043 DRILLING/ASSEMBLY DETAIL**



**D3274-043 BEND/DRILLING DETAIL**



**D3274-043 SKIDTUBE ASSEMBLY**  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

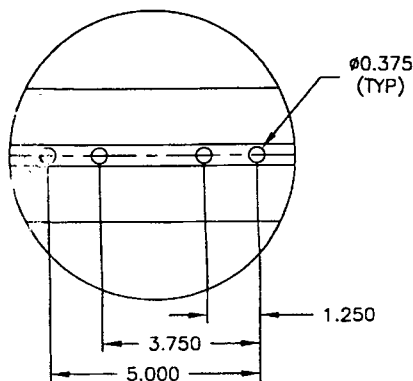
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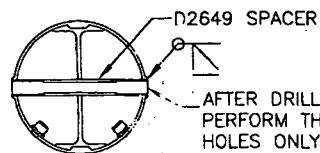
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							D3274	SHEET 3 OF 4
		DATE					TITLE	SCALE
		06.12.19					SKIDTUBE ASSEMBLY	1:15



# **DETAIL A: DRILL DETAIL**

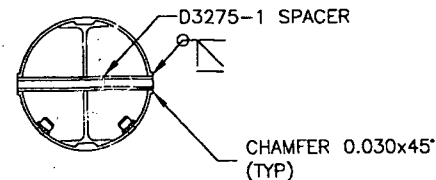


# **DETAIL B** FOR 0.375 HOLES ONLY

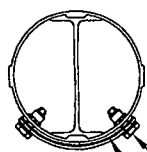


- AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR 0.375  
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
  2. INSERT D2649 SPACER
  3. WELD INTO PLACE AND GRIND FLUSH
  4. C'BORE TO 0.313x0.75 DEEP

# **DETAIL C** FOR 0.313 HOLES ONLY

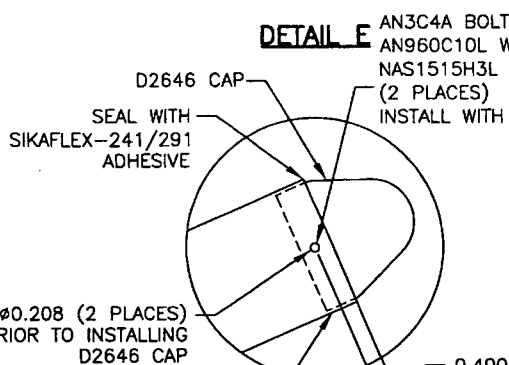


# **DETAIL D**



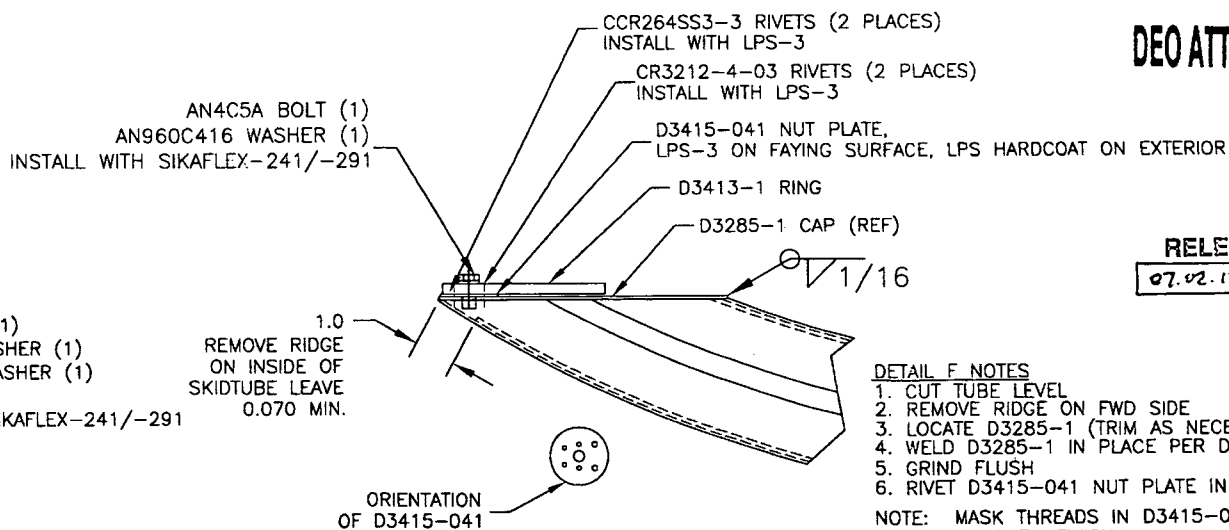
- ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
AN960C10L WASHER (1)  
(78 PLACES)  
GASKET/WEARSHOE/WEARPAD (REF)

# **DETAIL E**



BORE OUT END OF SKIDTUBE  
TO 0.75 DEPTH AND 0.070 WALL

# **DETAIL F: END FINISHING DETAIL**



- DETAIL F NOTES**
1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

**DEO ATTACHED**

**RELEASED**  
07.02.12

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		DATE	06.12.19	TITLE		SKIDTUBE ASSEMBLY	SCALE 1:3

*W/O 52865*

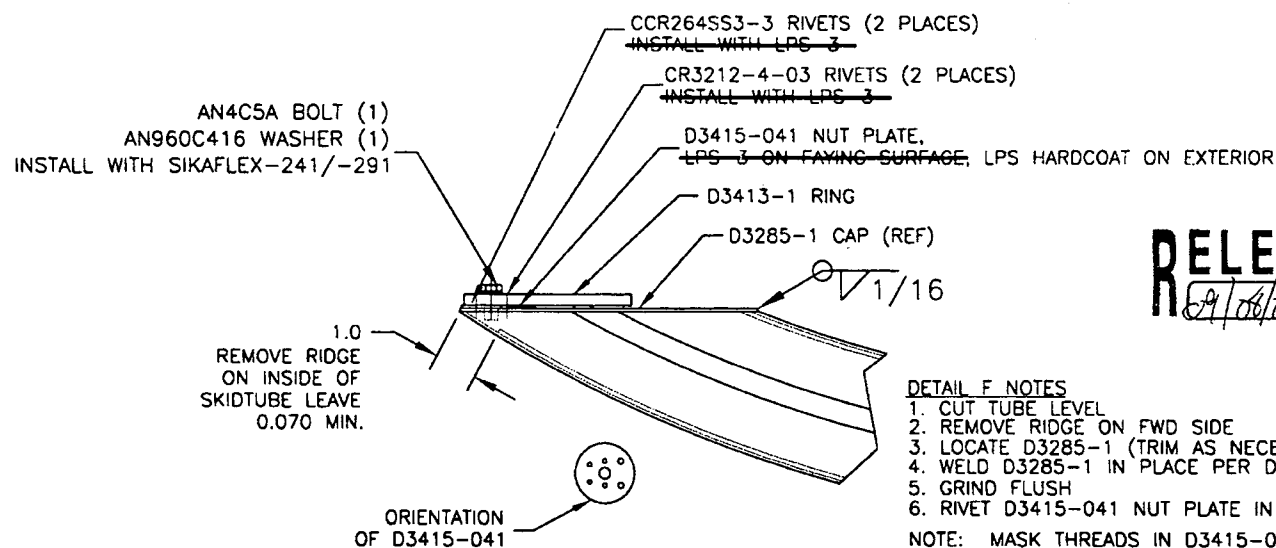
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

### DETAIL F: END FINISHING DETAIL



#### DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

*u/o 52868*

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